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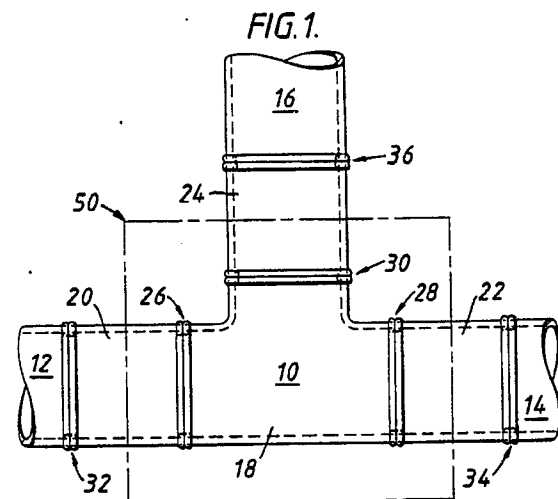
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⑤④ **Structures of plastics material.**

⑤⑦ Large fittings or other structures are made by rotationally moulding a first component 18 of polyethylene and joining cylindrical pups 20, 22, 24 of polyethylene to the component by butt fusion joints 26, 28, 30. The structure within the boundary 50 is irradiated with gamma radiation followed by post-heating to remove free radicals. The extremities of the pups are shielded to prevent irradiation. Their capability to be joined to polyethylene pipes 12, 14, 16 by butt-fusion joints 32, 34, 36 is unimpaired. The irradiation introduces cross-linking to give improved properties such as impact resistance and stress crack resistance and to bring the fitting within the specification for polyethylene pipe for natural gas distribution. The joints 26, 28, 30 are made using differential heating of the ends to be joined to compensate for differences in melt flow index. Alternatively, the component 18 is slightly irradiated to lower its MFI before pups are joined to it.



EP 0 256 825 A3



DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)
E	EP-A-0 246 030 (VICTAULIC) * Column 3, lines 22-37; claims 5-7 *	1-14	B 29 C 71/04 B 29 C 65/02
X	US-A-4 056 421 (JARVIS) * Abstract *	1	B 29 D 23/22 // B 29 L 31/24
A	US-A-3 989 787 (SCOTT) * Whole document *	1-14	
A	DD-A-0 152 236 (A.D.W.) * Example 3 *	1	
A	US-A-4 401 536 (LUNDELL) * columns 3,10-15 *	3	
A	DE-B-1 130 153 (NEOSID PEMETZRIEDER) * Column 3, lines 9-26 *	3	
A	FR-A-2 196 888 (PONT-A-MOUSSON) * Claim 1 *		
A	FR-A-2 393 664 (HEPWORTH IRON) * Claims; fig. *		
A	FR-A-2 463 787 (CARL FREUDENBERG) * Fig.; claims *		
The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
			B 29 C
Place of search THE HAGUE		Date of completion of the search 20-03-1990	Examiner CORDENIER J.
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	

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